

Date: Tuesday, 7/1/2008 2:33:38 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ACCESS PANEL ASSEMBLY
 Job Number : 40183
 Estimate Number : 13009
 P.O. Number :
 This Issue : 7/1/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D3245042
 First Issue : / / Type : SMALL /MED FAB Drawing Number : D3245 REV B
 Previous Run : 35650 Material :
 Due Date : 7/28/2008 Qty: 4 Um: Each
 Written By :
 Checked & Approved By : 08.07.01
 Comment : Est Rev: New Issue 07-09-11 JLM Verified By: EC
 Est Rev: b ECN 1052 07-10-31 DD verified by:

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

2.0 D32452 Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Panel
 Batch: B36401

NO ATT
 SN 08/09/03

3.0 D32455 Door



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Angle Plate
 Batch: B34607

SN 08/09/03

4.0 235018C3Y RIGID RECEPTACLE



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)
 RIGID RECEPTACLE
 Batch: M100031 M19688 x32

SN 08/09/02

5.0 MS20427M33 Rivet



Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)
 Rivet
 Batch: M106993 x18 M17654 x11

SN 08/09/02

Batch
 Not in comp

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/1/2008 2:33:38 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 40183

Part Number: D3245042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS20615M33

Rivet



used
M20615M33



Comment: Qty.: 9.0000 Each(s)/Unit Total : 36.0000 Each(s)

Rivet

M18235

Batch Not in amp

NS 08/09/02 (2)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Rivets and Nut Plates and D3245-5 angle as per Dwg D3245

08/09/03 (2)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/09/03

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart P# and B# using fine point permanent ink marker and Stock

Location: _____

08/09/03 (2)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/04

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-04

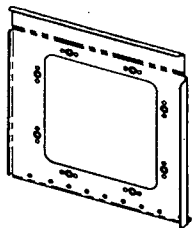
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

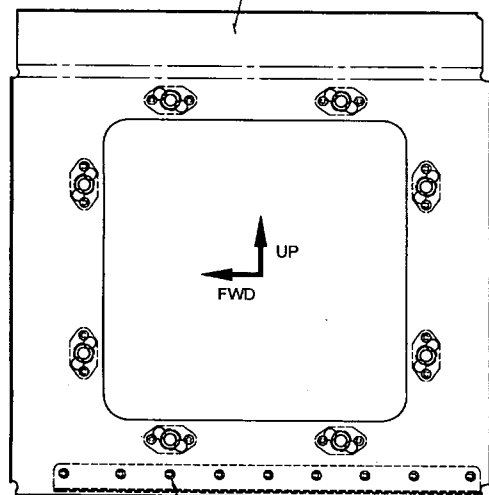
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3245-1
PANEL

2350-18-C3Y DZUS
RIGID RECEPTACLE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)



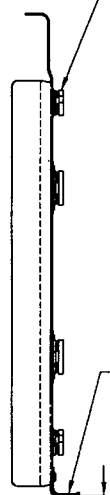
MS20615M3-3 RIVET
(9 PLACES)

D3245-041 ACCESS PANEL ASSEMBLY

RELEASED
07-10-23

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

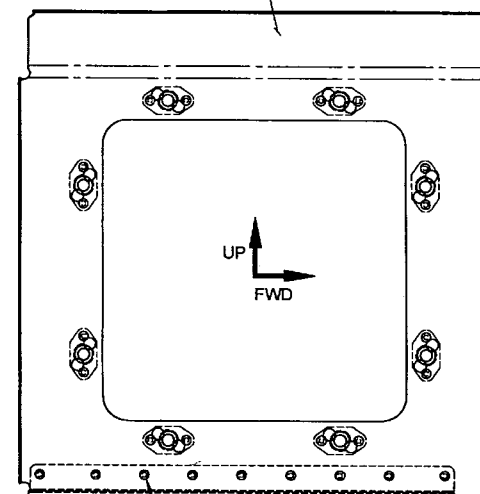


D3245-5
ANGLE PLATE

0.032
GAP

2350-18-C3Y DZUS
RIGID RECEPTACLE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)

D3245-2
PANEL

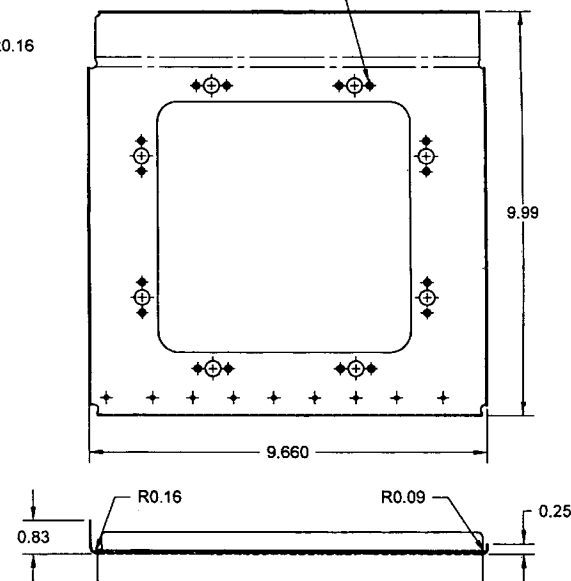
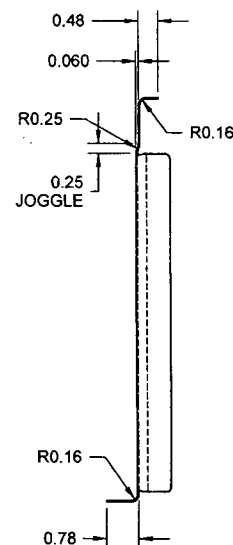
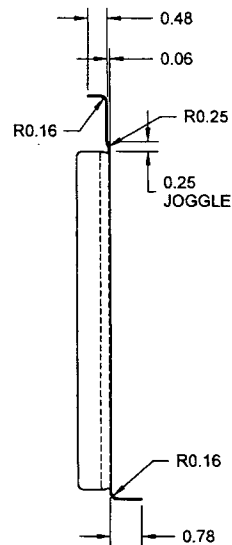
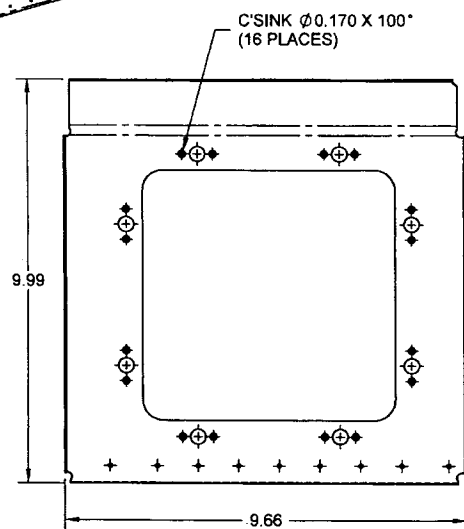
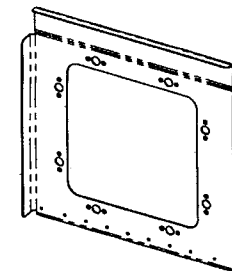
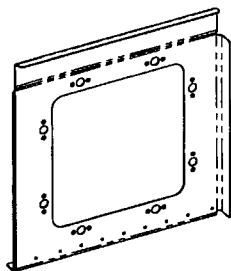


MS20615M3-3 RIVET
(9 PLACES)

D3245-042 ACCESS PANEL ASSEMBLY

QTY -041	QTY -042	P/N	DESCRIPTION
X	X	D3245-041	ACCESS PANEL ASSEMBLY, LH
	X	D3245-042	ACCESS PANEL ASSEMBLY, RH
1		D3245-1	PANEL
1	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

B	REMOVE Ø0.204 HOLES FROM D3245-1/-1F. REMOVE MS21060-L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/-042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING	MB	07.10.02
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TH	DART AEROSPACE LTD	
DRAWN	TH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	TH	DRAWING NO.	REV. B
MFG. APPR.	TH	D3245	SHEET 1 OF 7
APPROVED	TH	TITLE	SCALE
DE APPR.	TH	ACCESS PANEL ASSEMBLY	12.5
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D3245-1 PANEL BEND DETAIL, LH

D3245-2 PANEL BEND DETAIL, RH

RELEASED
07-10-23

- NOTES:
- 1) MATERIAL: MAKE FROM D3245-1F
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.70 lbs

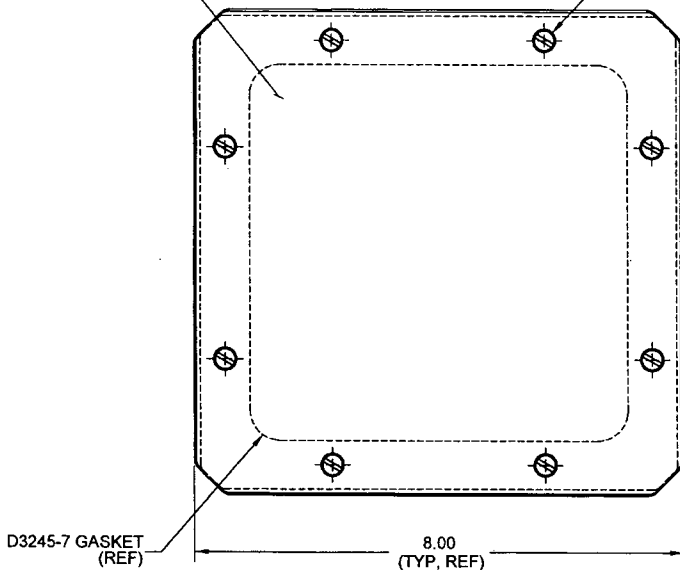
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DESIGN	TH	DART AEROSPACE LTD	
DRAWN	B	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	NS	D3245	SHEET 2 OF 7
APPROVED	NS	TITLE	SCALE
DE APPR.	TH	ACCESS PANEL ASSEMBLY 1:3	
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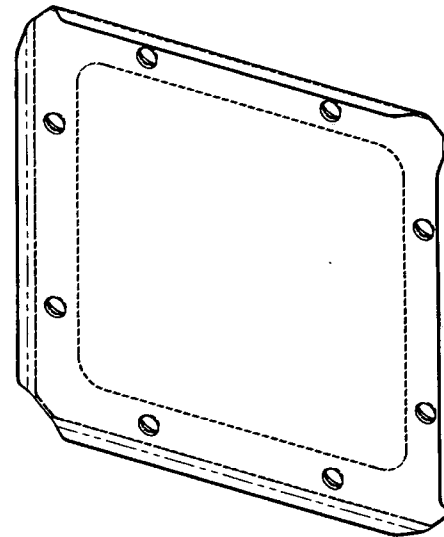
8 7 6 5 4 3 2 1

D3245-5 DOOR

2351-20-009-C3Y STUD (1)
127H-35 GROMMET (1)
(8 PLACES)



INSTALL D3245-7
GASKET ON THIS SIDE



D3245-043 DOOR ASSEMBLY

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSEMBLY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	2351-20-009-C3Y	STUD
8	127H-35	GROMMET

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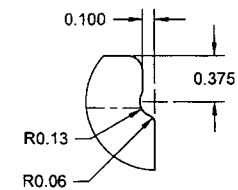
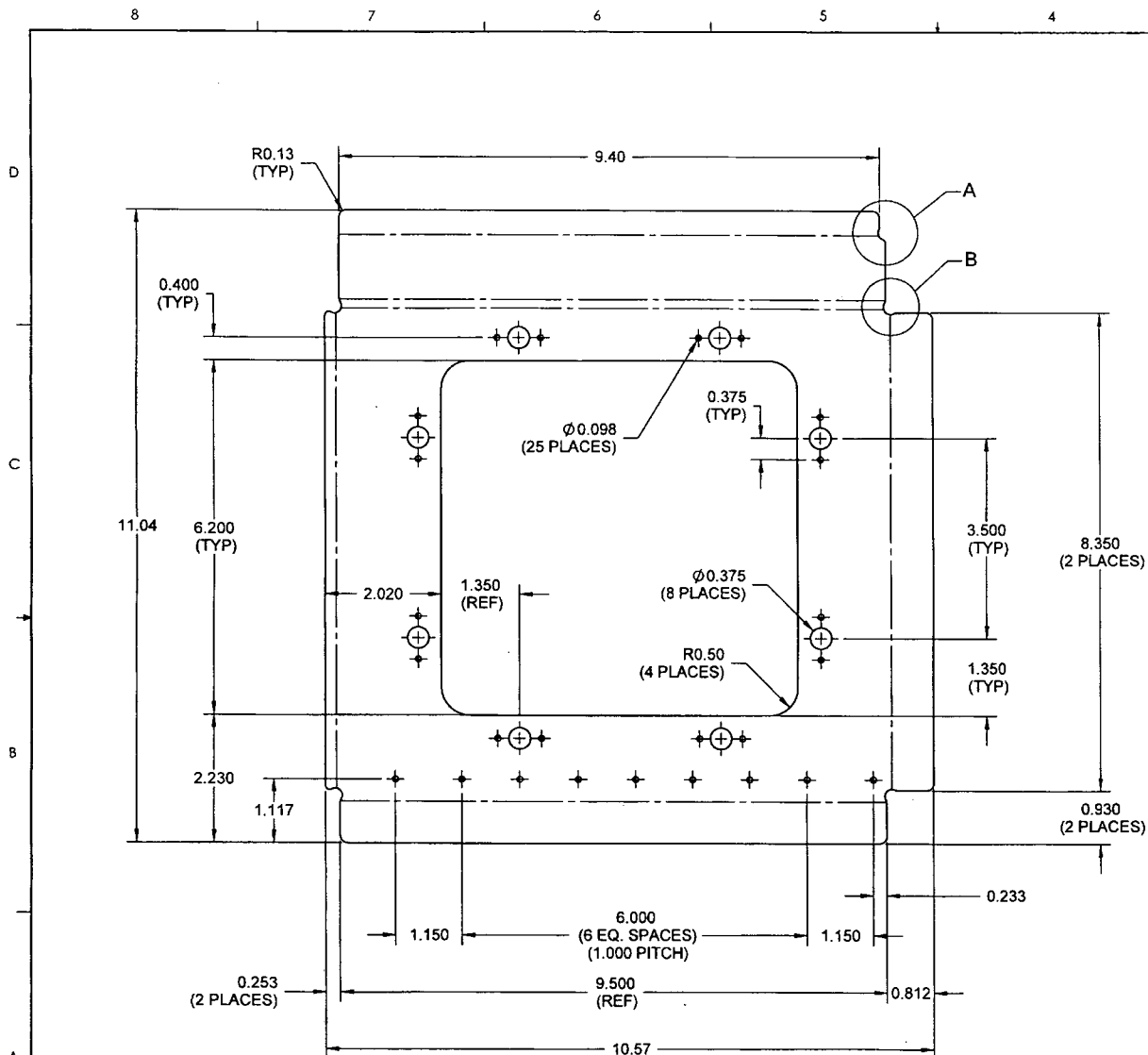
RELEASED
77 ID. 33

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
 - 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
 - 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
 - 9) WEIGHT: 0.73 lbs

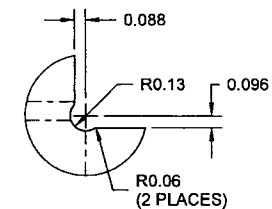
DESIGN		DART AEROSPACE LTD
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CHECKED		DRAWING NO. REV. B
MFG. APPR.		D3245 SHEET 3 OF 7
APPROVED		TITLE SCALE
DE APPR.		ACCESS PANEL ASSEMBLY 1:2
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8 7 6 5 4 3 2 1



DETAIL A: RELIEF
SCALE 1:1



DETAIL B: RELIEF
(TYP, 4 PLACES)
SCALE 1:1

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET
(0.032 THICK, REF)
PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3245	SHEET 4 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ACCESS PANEL ASSEMBLY	1:2
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[Handwritten: 1/16/03]

D3245-1F PANEL FLAT PATTERN

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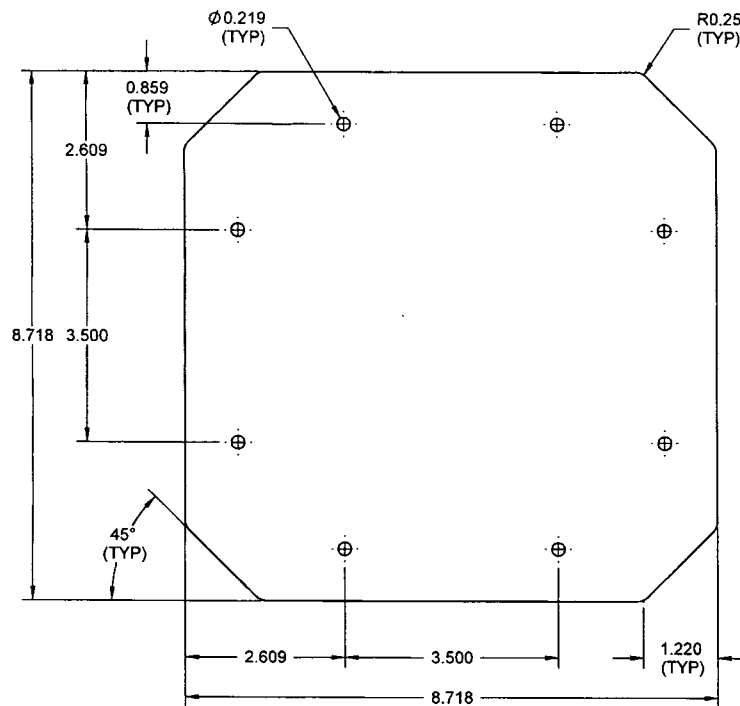
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D

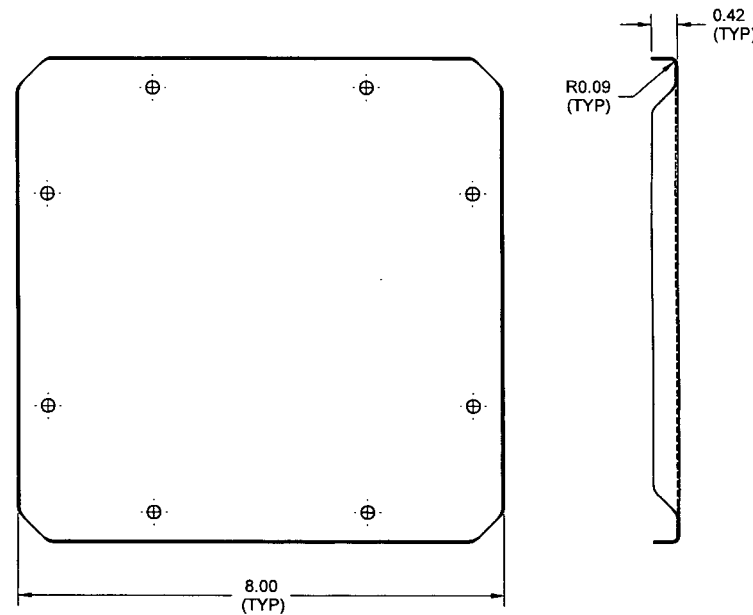
C

B

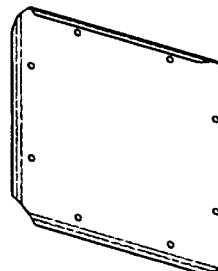
A



D3245-3F DOOR FLAT PATTERN



D3245-3 DOOR BENDING DETAIL









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07.10.02

NOTES:

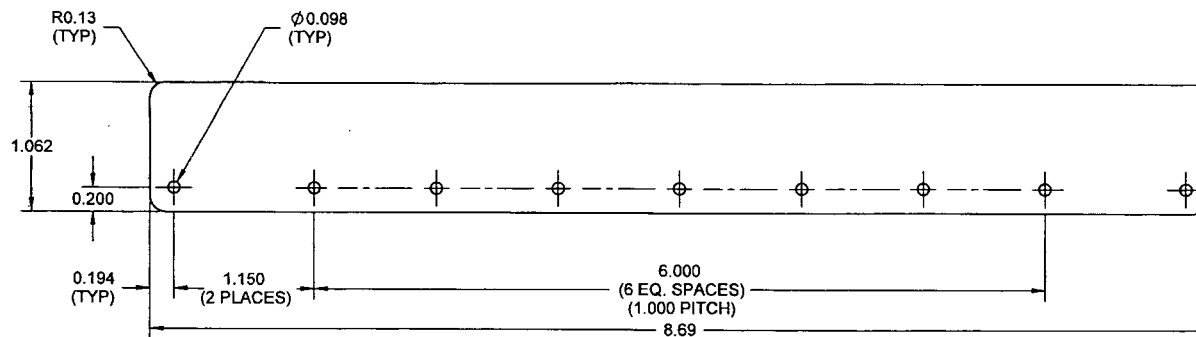
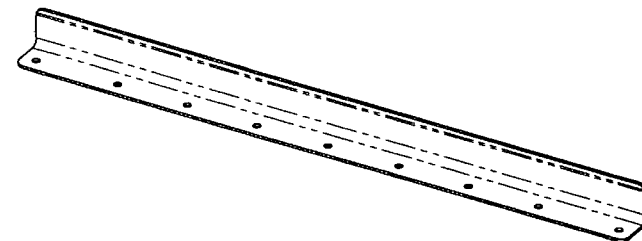
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.67 lbs

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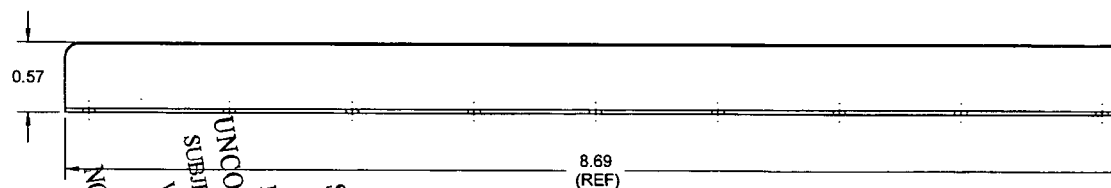
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3245	SHEET 5 OF 7
APPROVED		TITLE	SCALE
DE APPR.		ACCESS PANEL ASSEMBLY	
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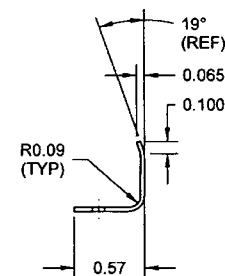
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D3245-5F FLAT PATTERN



D3245-5 BEND DETAIL
(MAKE FROM D3245-5F)



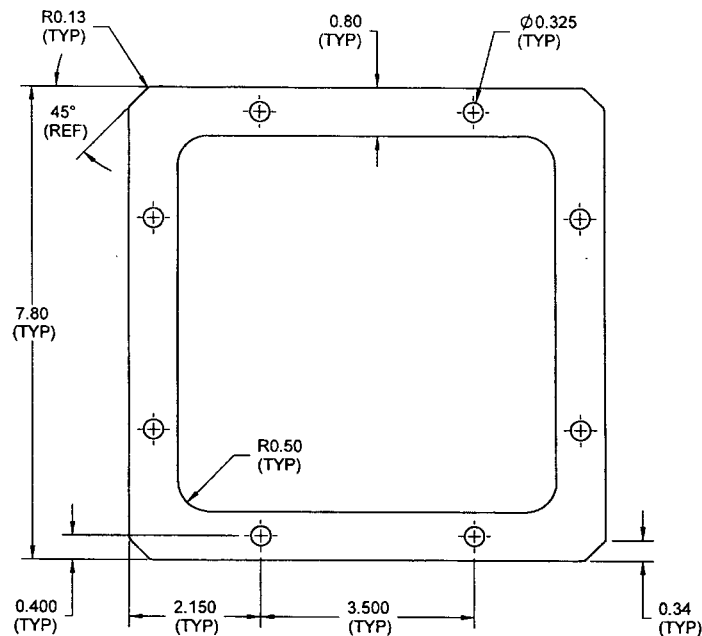
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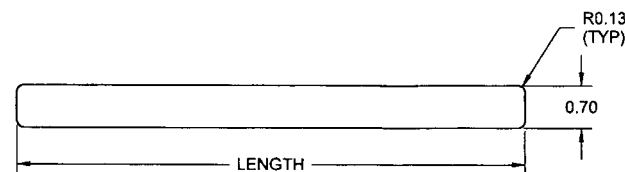
- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)
PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S22GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.08 lbs

DESIGN	TF	DART AEROSPACE LTD	
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CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	SS	D3245	SHEET 6 OF 7
APPROVED	140	TITLE	SCALE
DE APPR.	140	ACCESS PANEL ASSEMBLY	1:1
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8 7 6 5 4 3 2 1



D3245-7 GASKET



D3245-X GASKET

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

RELEASED
07.10.02

NO. 1018
WORK ORDER
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- NOTES:
- 1) MATERIAL: DURABLE BLACK GASKET, 0.035 THICK (PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	B	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	DS	D3245	SHEET 7 OF 7
APPROVED	DS	TITLE	SCALE
DE APPR.	PH	ACCESS PANEL ASSEMBLY	
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